

Date: Friday, 14/11/2008 10:21:01 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	206 A/B LOW GEAR WEB
<b>Job Number</b> :	43445		
<b>Estimate Number</b> :	11768		
<b>P.O. Number</b> :		<b>Part Number</b> :	D26541
<b>This Issue</b> :	14/11/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2654 REVE1
<b>First Issue</b> :	11	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	41267	<b>Drawing Revision</b> :	E1
	<b>Type</b> :	<b>Material</b> :	
	SKIDTUBES	<b>Due Date</b> :	28/11/2008
<b>Written By</b> :		<b>Qty:</b>	1
<b>Checked &amp; Approved By</b> :	JLD 08.11.14	<b>Um:</b>	Each
<b>Comment</b> :	Est Rev:D 99.02.04 Fixed typo, Changed procedure DM Est Rev:E 08-06-10 revE1 as per dwg DD verified by:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D2600-5	Web

Batch

B 38589

D

H

2-11-17

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2654 (73.85")

2-Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

H 2-11-17

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



1

**Comment:** INSPECT WORK TO CURRENT STEP

DP 8-11-17

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005.4.1

M/MB 08-11-17

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

Date: Friday, 14/11/2008 10:21:01 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B LOW GEAR WEB

Job Number: 43445

Part Number: D26541

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W 8-11-18

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 6b

W 8-11-18

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/27 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08.11.27

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

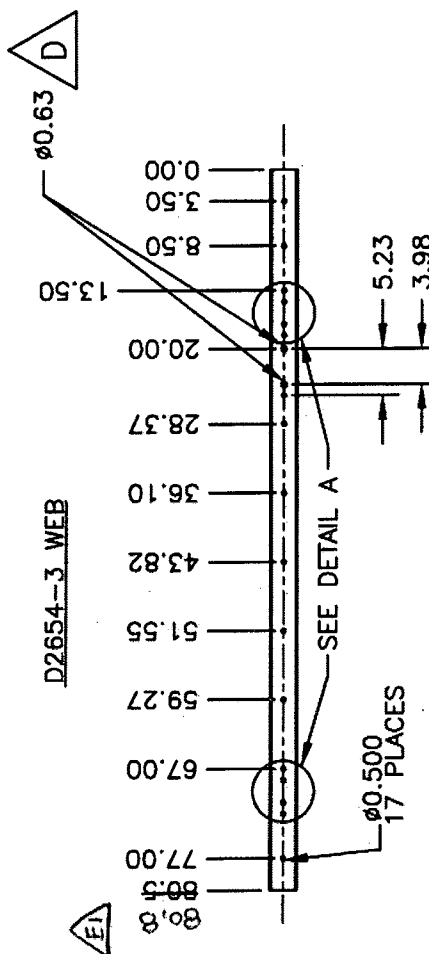
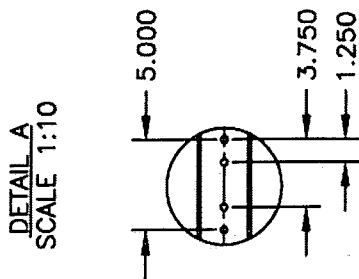
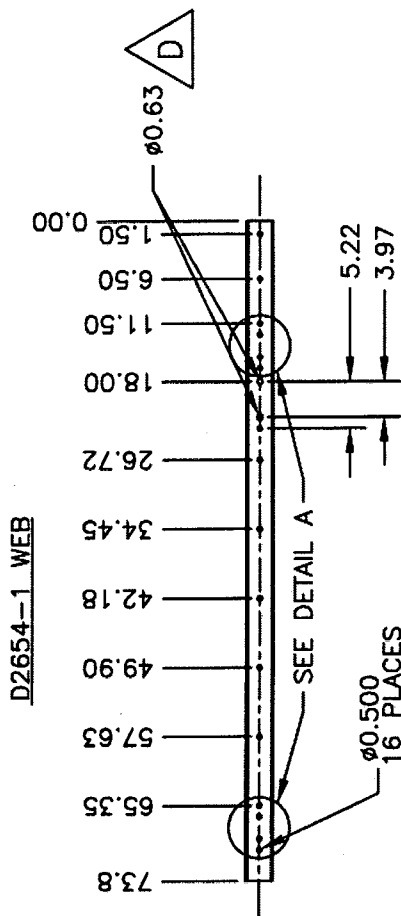
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20
A	97.03.25	NEW ISSUE	
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438	
C	97.10.29	CHANGED HOLE PATTERN	
D	98.01.15	GHW HOLES CHANGED TO Ø0.63	
E	04.05.26	CHANGE LENGTHS, REFORMAT	
E1 <i>CP #</i>	04.08.24	PER TOOLING; 80.8 WAS 80.5	

RELEASED  
64.06.22



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WORK ORDER  
NO. 43445

MAKE FROM D2600-5-108 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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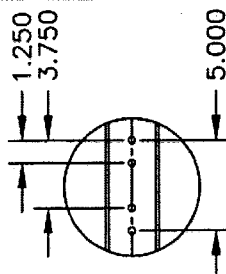




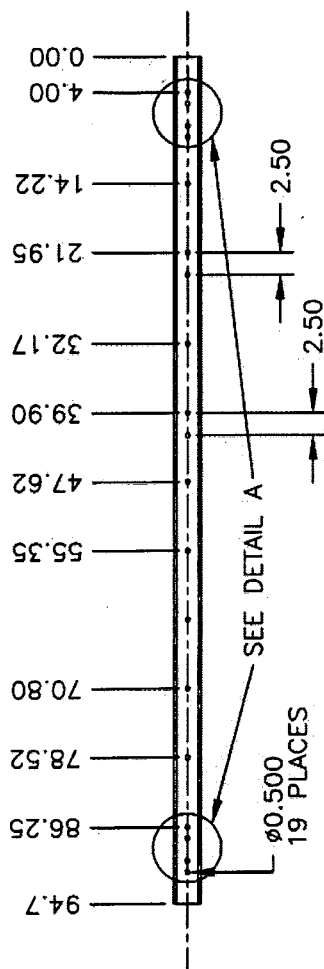
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20

RELEASED  
04.06.22

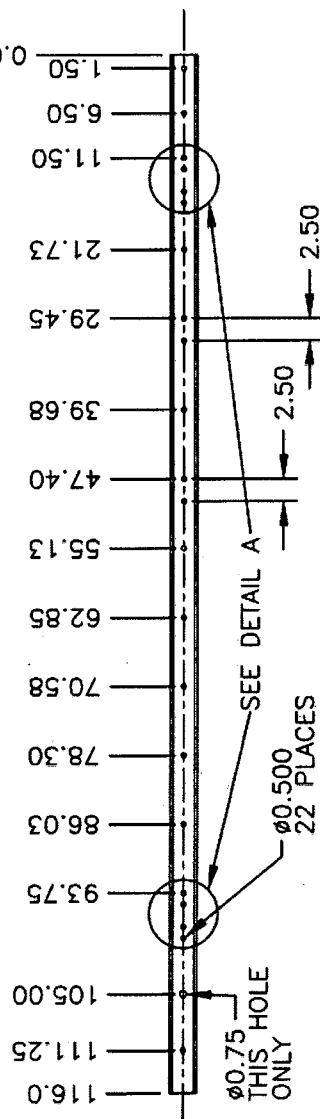
DETAIL A  
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI Q05 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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